

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030028**Date Inspected:** 04-Sep-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

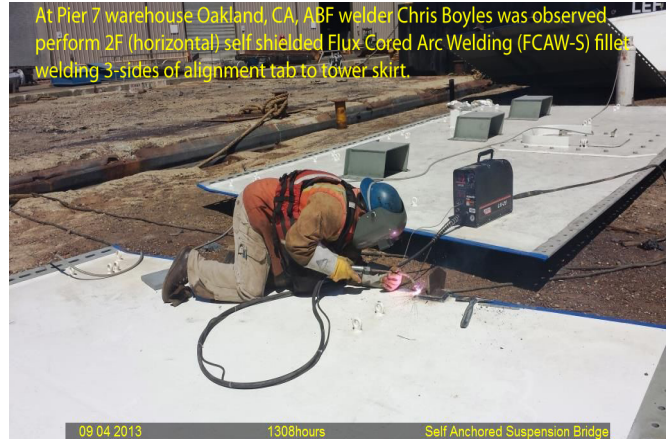
At Pier 7 warehouse of Oakland CA, this QA randomly observed ABF welder Chris Boyles perform 2F (horizontal) fillet welding adjustment tab for the erection/installation of tower skirt. The welder was noted using self shielded Flux Cored Arc Welding (FCAW-S) with 0.072" diameter E71T-8 wire electrode. The welder was noted welding alignment tab type 1 for straight portion of the connections while using alignment tab type 2 for bent portion of the connections. The welder was also noted 5mm fillet welding three (3) sides of the tab to the tower skirt panels. During welding, ABF QC Salvador Merino was onsite monitoring the progress, parameters and workmanship of the fillet being welded. At the end of the shift, two adjustment tabs welded each of the approximately 20 skirt panels were completed. Welded 5mm fillets on the adjustment tabs to the skirt plates deemed in compliance to the project requirements.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant conversation occurred today.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Reyes, Danny

QA Reviewer